

Date: Thursday, 5/25/2006 3:26:37 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 27244		
Estimate Number	: 10192		
P.O. Number	: N/A	Part Number	: D2171
This Issue	: 5/25/2006 S.O. No. : N/A	Drawing Number	: D2171 REV. D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: D
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/15/2006 Qty: 100 Um: Each
Checked & Approved By	: <u>06.05.25</u>		
Comment	: Est: F 01.11.29 Reformat SM/EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1352C206105130(100)

Laser cut as per Dwg D2171

Material: 304/316 SS 0.063" thick

Material release note required

2.0	D2171F	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)  
 CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

Rec'd(100)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK  
 (4.158" center to center)

060705

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Deburr

2- Bend as per Dwg D2171

3- Tumble

ALREADY BENT.Sad 06107105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/07/05

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 5/25/2006 3:26:38 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 27244

Part Number: D2171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JP 06/07/05

102

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 219

P 06/07/05 102

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/07/05

102

Job Completion



U 06-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

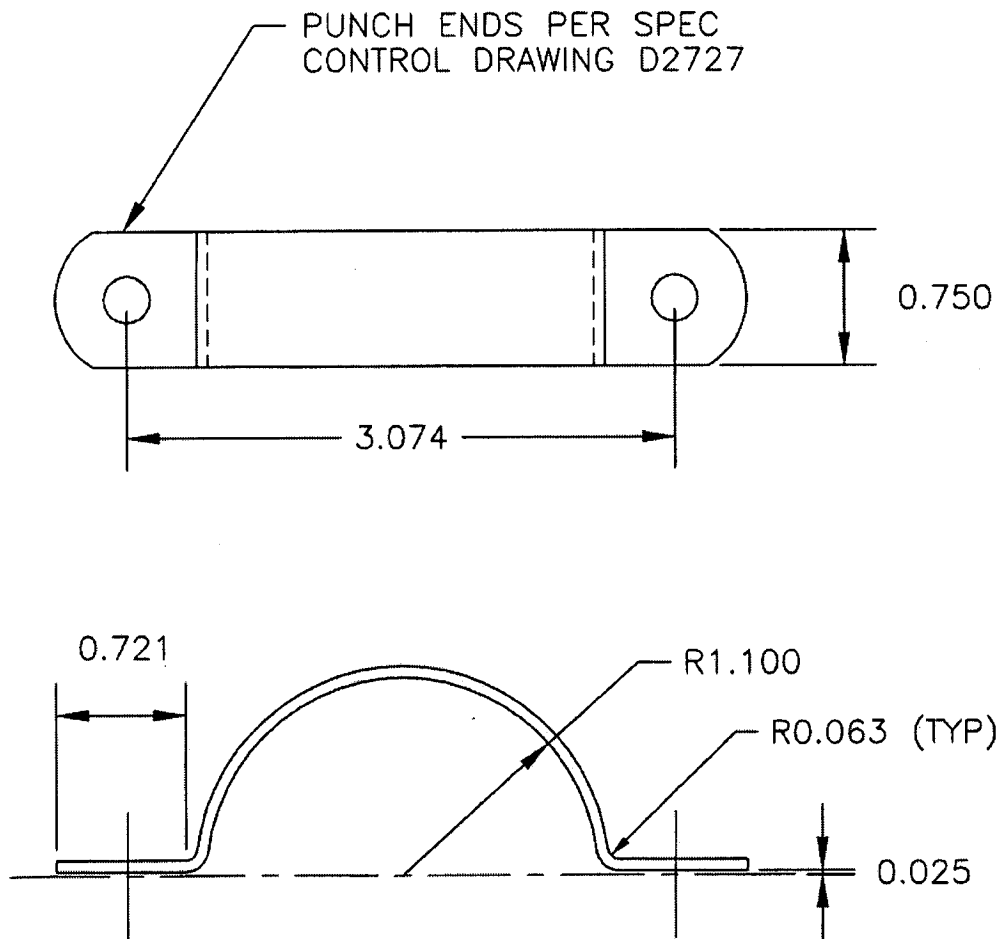
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN BW	DRAWN BY <del>DA</del>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2171	REV. D SHEET 1 OF 1
DATE 99.03.08		TITLE CLAMP	SCALE 1:1
B	96.01.29	REDRAWN	
C	97.05.14	RADIUS CHANGED, CUSHION ADDED	
D	99.03.08	REMOVE CUSHION (TSR A890) 4.158 WAS 4.888	

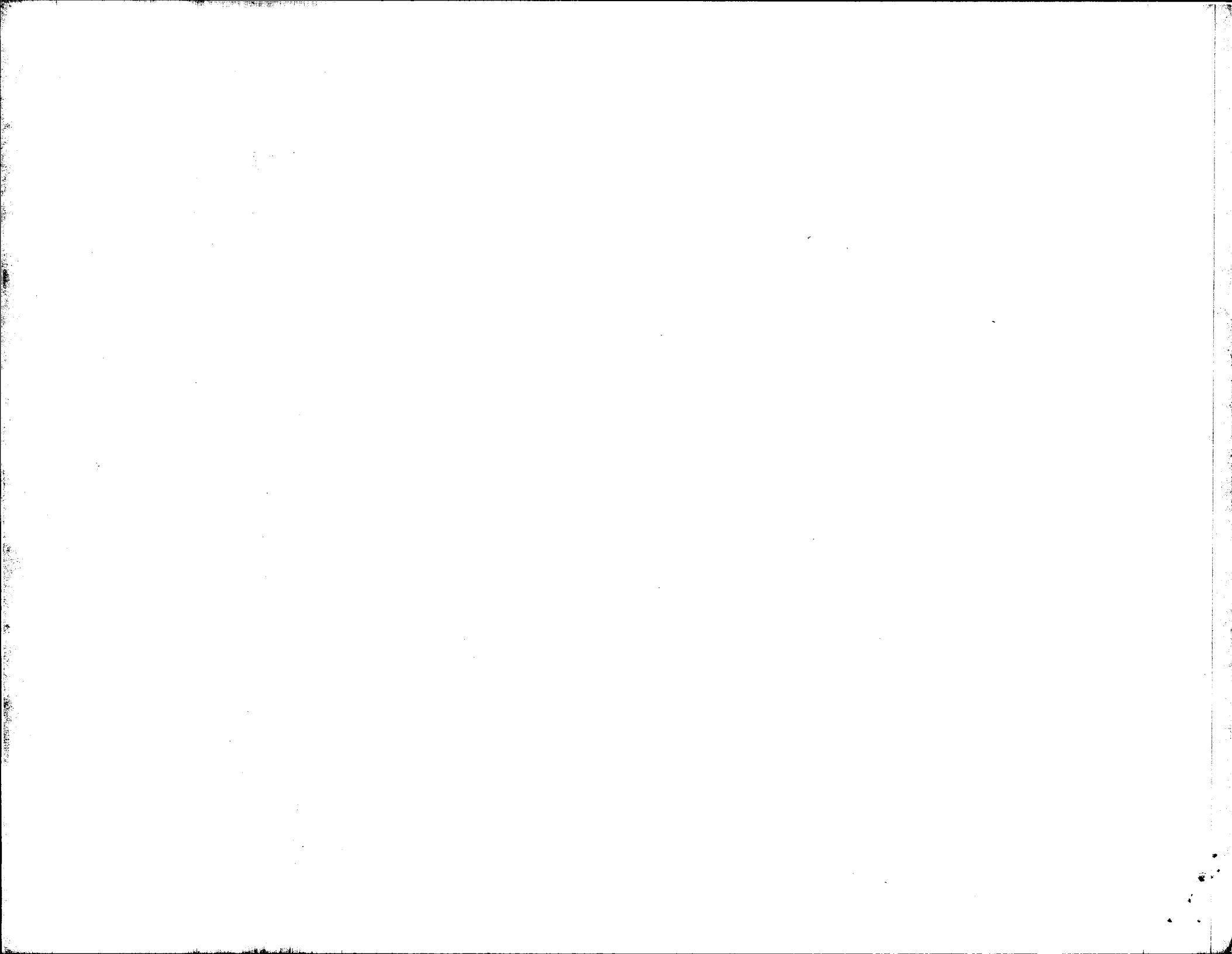
RELEASED  
99.03.11 KE



MATERIAL: 304/316 SS 0.063 THICK  
FLAT LENGTH: 4.968 END-END  
4.158 HOLE-HOLE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27244



CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	1	OUR JOB NO	J0144270	SHIPPING MEMO	0340503	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	100 PCS	PO00001352	D2171	D	CLAMP	D
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
S.S.T 304		TW METALS / AK STEEL		H/N # 7360176 ATT'D		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 03 JULY 2006

G.F.I. Q.C. REP.

*B. Samiec*



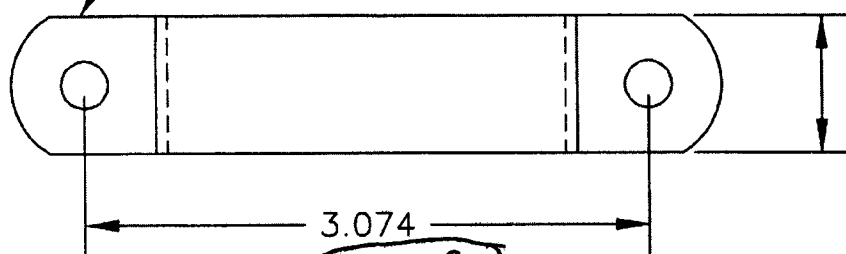


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RELEASED  
99.03.11 KE

PUNCH ENDS PER SPEC  
CONTROL DRAWING D2727

✓ comply.



0.750

.752

3.074

3.083

0.725

0.721

MYLAR

R1.100

PLAN MAÎTRE

02 JUN 2006

R1.100

R0.063 (TYP)

R.062 TYP

0.025

0.025

061

MATERIAL: 304/316 SS 0.063 THICK  
FLAT LENGTH: 4.968 END-END  
4.158 HOLE-HOLE

